Patent claims

1. Method for producing a conductive contact part (10) for a detachable electrical plug-in connection, where a contact element (20) with a sectionally lengthwise slotted bushing part (23), featuring ribs (26) arranged distributed around its circumference is provided, and a sleeve part (30) surrounding the bushing part (23) and covering its ribs (26) is provided with two opposing end faces (31, 32),
characterized in that,
the sleeve part (30) is arranged and positioned almost coaxially to the bushing part (23) so as to cover its ribs (26), that the positioned sleeve part (30) is locked by one of its two ends (31, 32) on the bushing part (23), that the bushing part (23) is twisted elastically around the central axis (13) such that the ribs (26) bend in the shape of arcs towards the central axis (13), and that the sleeve part (30) is locked with the other of the two ends (32, 31) to the bushing part (23) held twisted against the elastic recovery force of the ribs (26).

2. Method according to Claim 1,
characterized in that,
the sleeve part (30) is locked onto to the bushing part (23) by mechanical locking.

3. Method according to Claim 1,
characterized in that,
the sleeve part (30) is locked onto to the bushing part (23) by laser welding.

4. Method in accordance with one of the Claims 1 to 3,
characterized in that,
a radial expansion protection ring (37) extending around the circumference is pressed into the positioned sleeve part (30).

5. Method in accordance with one of the Claims 1 to 4, characterized in that, at least one radially extended section (24, 25) is formed on the contact element (20).

6. Method in accordance with one of the Claims 1 to 5, characterized in that, that flat contact arrangements of the contact element (20), and if necessary of the sleeve part (30) repeating at a particular spacing distance are punched out of a strip material, with the arrangements remain connected to a carrier tape (40) of the strip material, that the punched-out contact arrangements are surface-treated, and that the contact element (20) is formed from the contact arrangements by rolling the bushing part (23) and bending up connection tabs (21, 22) and if necessary the sleeve part (30), is formed through rolling.

7. Method according to Claim 6, characterized in that, locating tabs (33) and locating cutouts (34) arranged in pairs are formed on the contact arrangement of the sleeve part (30), in which case, when the sleeve part (30) is rolled, the locating tabs (33) engage in the assigned locating cutouts (34) to form a tight fit.